



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5735-3

Job Sheet 203904



Part No: D5735-3

Job Qty: 1 pcs

Part Name: MID Wearplate



Part Weight: 0 lbs

Status: New

Job Created: 11/28/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 19-1206 DWG D5735/DSK193-1 Rev.A/A IPP Rev. A 19.11.08 New issue DP Verify DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 12/1/28 AUTH SMD

RELEASED 9 DATE 12.11.20

Priority: Medium

ok to release

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1	11/29/19	11/29/19	0.17	0.25	Waterjet - Flow		JRB 11/28/19
		pcs							
110	QC 2	1	11/29/19	11/29/19	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Date: 11/28/19

KUSHI

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S235707



Part: D5735-3
Job No: 203904
Serial No/Batch: S235707

Revision: U/R A & A
Inspector:
Exp Date:
Instructions:

Plex 11/28/19 10:52 AM Dart.lajeunesse.marie

120 QC 8	1 pcs	11/29/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	DAS
				QC 8 - 40	40
				QC 8 - 52	NOV 28 2019 9-89
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	1 pcs	11/29/19	0.25 0.17	Small Fab - Brake - 1 - B4B	DAS 30 NOV 28 2019 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	1 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 NOV 28 2019 9-89
				QC 5 - 61	
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	1 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	

DAS

9

9-89

POSITIVE
RECALL

See Part Dual

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	62
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	3-00

Part Op 100 - 1-Cut DSK193-3F as per dwg prog rev: A dwg rev: A 2-Deburr if required

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per dwg D5735

140 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: W4001

160 - QC21- Final Inspection - Work Order Release

NOV 29 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.6300 sf (1.63 ea)	100-Waterjet - Flow - 1	5207058

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	2	121	0

Part Specifications

Specifications could not be found.

Plex 11/28/19 10:52 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			
Other/Details:					

DART AEROSPACE LTD		Work Order: 203904
Description: wear plate M10		Part Number: DSK193-3
Inspection Dwg: DSK193	Rev: A	Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ 0.188	+1-0.005 -1-0.001	0.187	✓			
0.400	+1-0.010	0.403	✓			
R0.50	+1-	R0.50	✓			
0.300	+1-0.010	0.301	✓			
R0.13	+1-	R0.13	✓			
1.36	+1-0.030	1.36	✓			
R1.00	+1-	R1.00	✓			
0.15	+1-0.030	0.152	✓			
R0.08	+1-	R0.08	✓			
0.50	+1-0.030	0.505	✓			
R0.13	+1-	R0.13	✓			
0.60	+1-0.030	0.60	✓			
0.50	+1-0.030	0.504	✓			
0.19	+1-0.030	0.19	✓			
0.38	+1-0.030	0.38	✓			
R0.06	+1-	R0.06	✓			
0.13	+1-0.030	0.131	✓			
63.06	+1-0.030	63.06	✓			
61.660	+1-0.010	61.660	✓			
1.38	+1-0.030	1.38	✓			
2.75	+1-0.030	2.75	✓			
4.25	+1-0.030	4.25	✓			
2.13	+1-0.030	2.13	✓			
3.00	+1-0.030	3.00	✓			
1.50	+1-0.030	1.50	✓			
1.855	+1-0.010	1.855	✓			
3.710	+1-0.010	3.710	✓			
62.31	+1-0.030	62.31	✓			
56.91	+1-0.030	56.91	✓			

Measured by:	Checked by:	QC Inspector:
Date:	Date:	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 2	

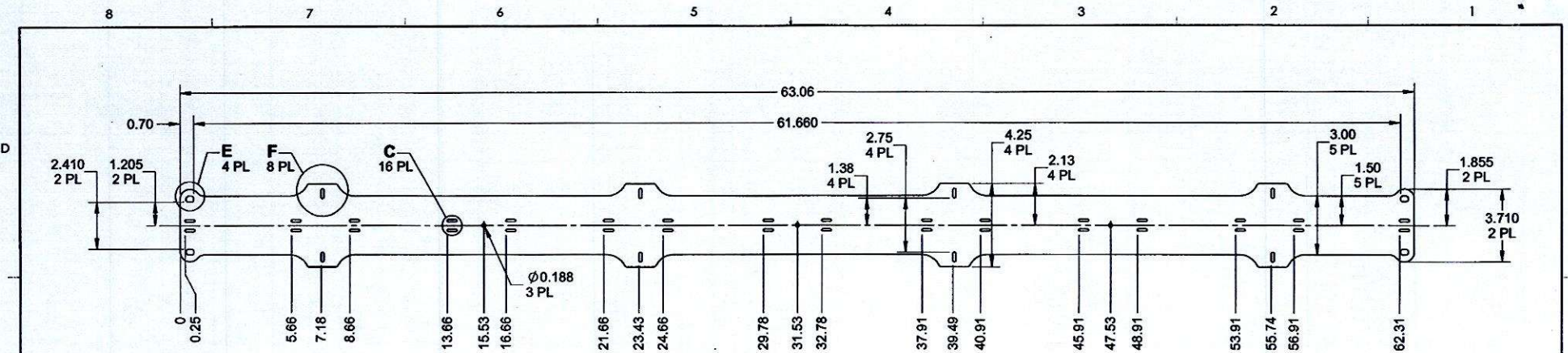
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
55.74	+/- 0.030	55.74			JRB-01V	
53.91	+/- 0.030	53.92			JRB-02V	
48.91	+/- 0.030	48.93			Tape	
47.53	+/- 0.030	47.51				
45.91	+/- 0.030	45.91				
40.91	+/- 0.030	40.91				
39.49	+/- 0.030	39.48				
37.91	+/- 0.030	37.92				
32.78	+/- 0.030	32.78				
31.53	+/- 0.030	31.53				
29.78	+/- 0.030	29.78				
24.66	+/- 0.030	24.66				
23.43	+/- 0.030	23.45				
21.66	+/- 0.030	21.67				
16.66	+/- 0.030	16.66				
15.53	+/- 0.030	15.50				
13.66	+/- 0.030	13.66				
8.66	+/- 0.030	8.66				
7.18	+/- 0.030	7.18				
5.66	+/- 0.030	5.66				
0.25	+/- 0.030	0.25				
2.410	+/- 0.030	2.412				
1.205	+/- 0.030	1.206				
0.70	+/- 0.030	0.70				

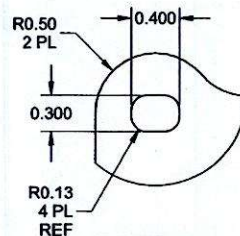
Measured by: JRB	Checked by: AD	QC Inspector:
Date: 11/28/19	Date: 19.12.10	Date:

Engineering Approval: (If necessary)	Date:
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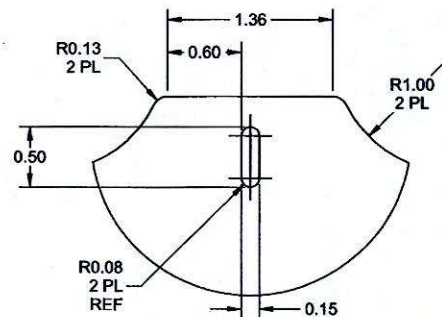
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



DSK193-3F FLAT PATTERN



DETAIL E



DETAIL F

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) THICK
PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.53 lbs
- 8) USE TO MAKE D5735-3

RELEASED
2019-11-13

DESIGN	ZF	DART AEROSPACE USA, INC.	
DRAWN	ZF	HILLSBORO, OR	
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	DD	DSK193	SHEET 2 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	N/A	WEARPLATE FLAT PATTERN	NTS
DATE	19.08.22	COPYRIGHT © 2019 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	